

Date: Monday, 08/09/2008 8:06:26 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	CABLE GUARD
Job Number :	41875	Part Number :	D34993
Estimate Number :	12410	Drawing Number :	D3499 REV B
P.O. Number :		Project Number :	N/A
This Issue :	08/09/2008	Drawing Revision :	B
Prsht Rev. :	NC	Material :	
First Issue :	/ /	Due Date :	15/09/2008
Previous Run :	28503	Qty:	6
Written By :		Um:	Each
Checked & Approved By :			
Comment :	Est Rev:A New Issue 06-05-05 JLM Est Rev:B As per Rev B 06-08-31 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MUHMWB625	UHMW .625 Black Tivar 1000
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Comment: Qty.: 1.1351 sf(s)/Unit Total: 6.8103 sf(s)

UHMW .625 Black Tivar 1000

Batch: 109313 AB 8-9-18

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3499

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

11

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:**

HAAS CNC VERTICAL MACHINING #1





1- Mill as per Folio FA636 Rev: B & Dwg D3499 Rev: B

2-Deburr per dwg D3499

H.A 08/09/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3499-3 PAR # NA Fault Category: Prod / Ex. Co. NCR: Yes No DQA: DD Date: 08/18/09
D3499-012 / D412-742-018 Resolution: _____ Disposition: machined parts. QA: N/C Closed: DD Date: 08/18/09

NCR: <u>41875</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/09/27	4.0	All the Y-values in the program were wrong for prog #1000 The mat is not thick enough at some places	 08/10/09	Scrap and Destroy no replace. Qty (X) - extra was cut on work J.E.	J.A. 08/09/27	S 08/09/29	 08/10/09	S 08/09/29
		The gage was not The Dim of 0.630 was machined at 0.493"		Fix program to prevent scrapping gram				
08/10/03	6.0	First counter bore was start on the wherry side about .083" deep P.C. operator error	 08/10/03	Scrap no replace Qty (X)	S.J.F. 08/10/03	S 08/10/03	 08/10/03	S 08/10/03

NOTE: Date & initial all entries

Date: Monday, 08/09/2008 8:06:26 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABLE GUARD

Job Number: 41875

Part Number: D34993

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

L.A 08/09/27

6.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE
C'BORE AS PER DWG D3499

88 08/02/03 (7)

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

← (PTD)
88 08/10/07

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

2nd 08/10/03 (7)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST207

ND 08/10/06 (7)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/08 H

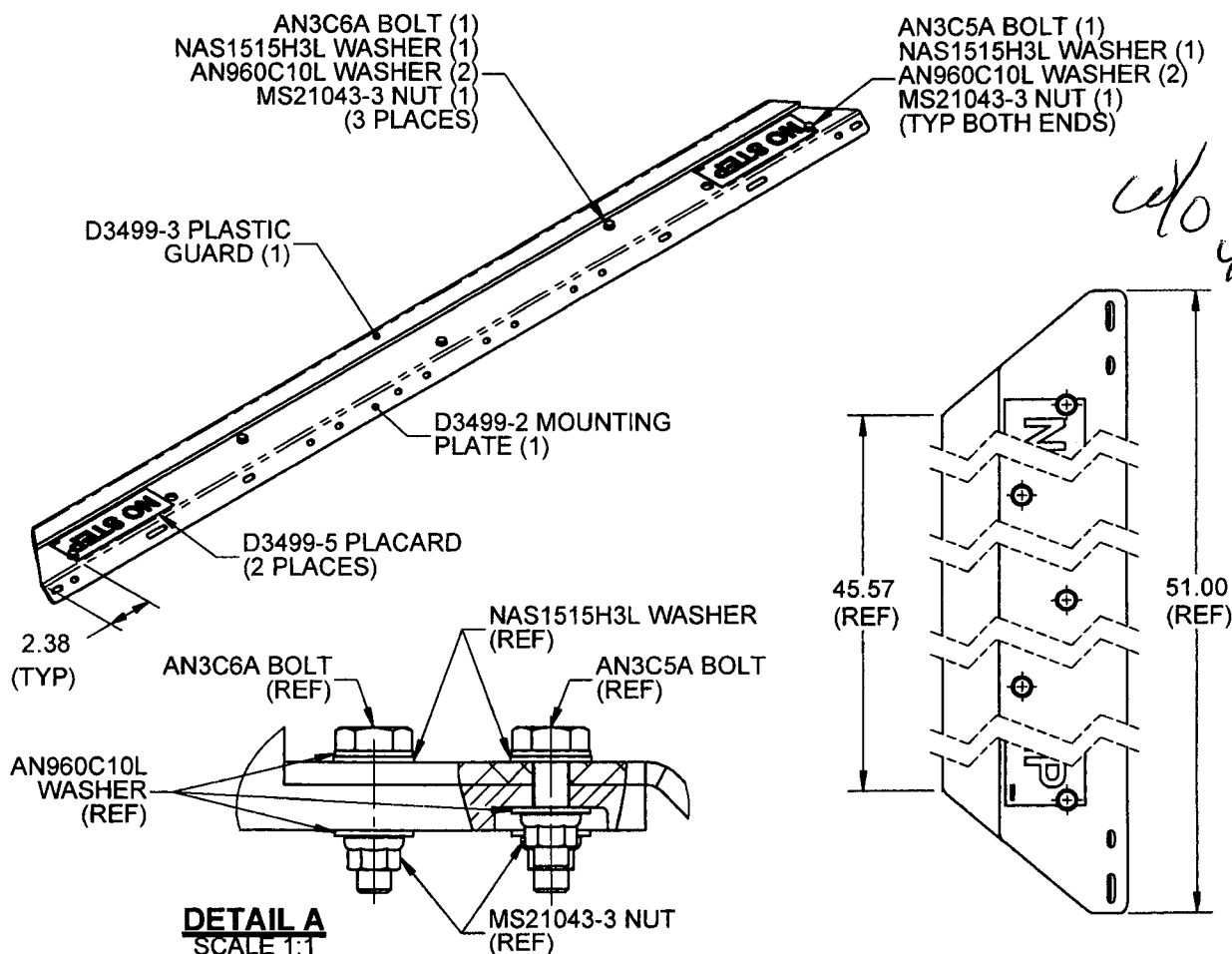
Job Completion



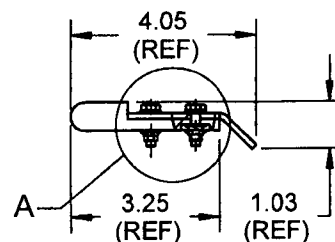
u 08/10/06

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3499	REV. B SHEET 1 OF 4
DATE 06.08.15		TITLE CABLE GUARD	SCALE 1:4
A	06.04.11	NEW ISSUE	
B	06.08.15	RE-DESIGN D3499-2F/-3	

**D3499-042 CABLE GUARD ASSEMBLY**

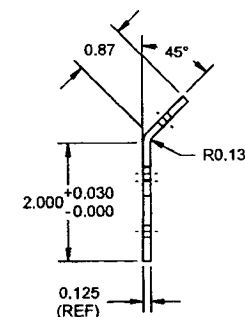
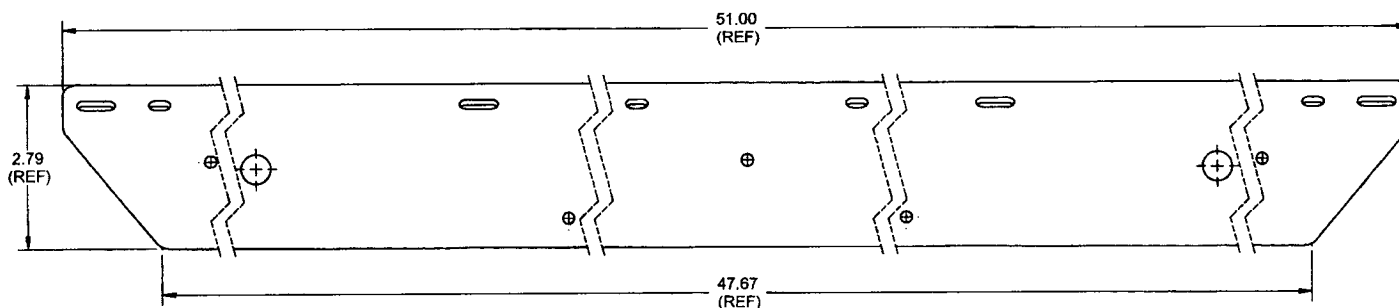
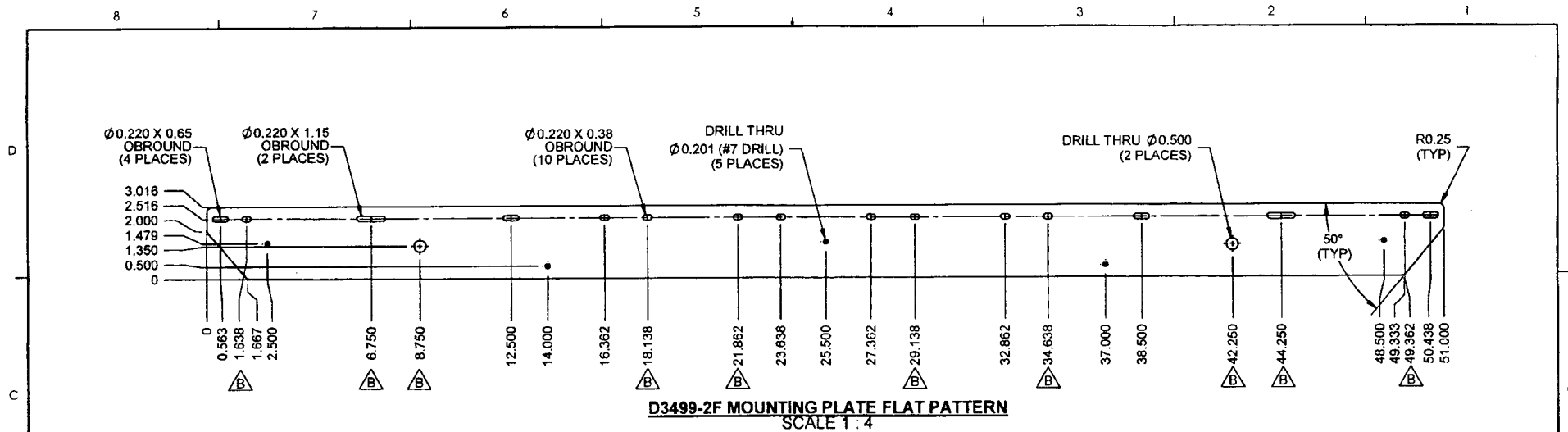
QTY -042	P/N	DESCRIPTION
X	D3499-042	CABLE GUARD ASSEMBLY
1	D3499-2	MOUNTING PLATE
1	D3499-3	PLASTIC GUARD
2	D3499-5	PLACARD
2	AN3C5A	BOLT
3	AN3C6A	BOLT
10	AN960C10L	WASHER
5	MS21043-3	NUT
5	NAS1515H3L	WASHER

**NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NOTES:

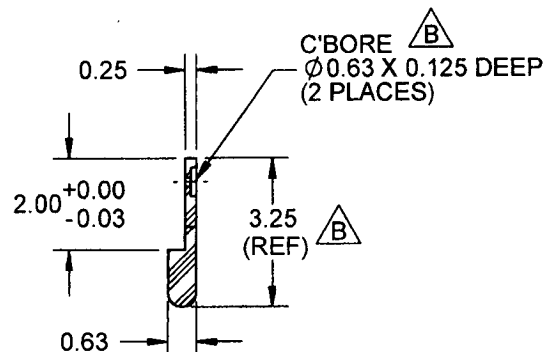
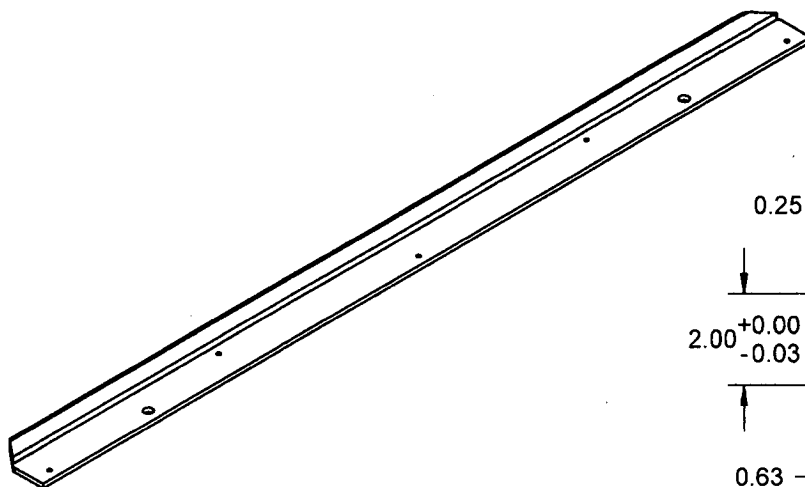
- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (0.125 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005. 4.1
POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

41875

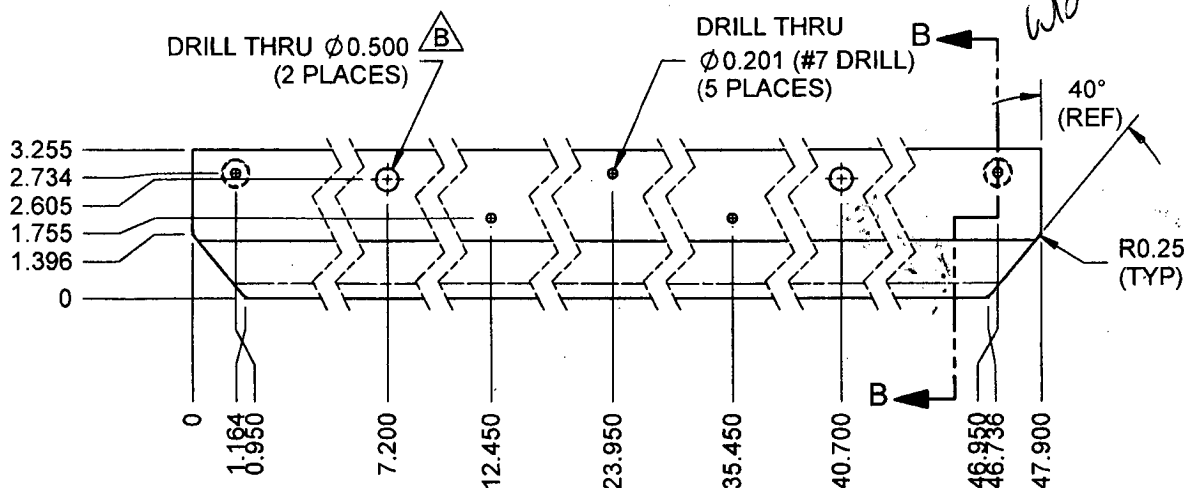
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3499	REV. B SHEET 2 OF 4
DATE 06.08.15		TITLE CABLE GUARD SCALE 1:2	
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3499	REV. B SHEET 3 OF 4
DATE 06.08.15		TITLE CABLE GUARD	SCALE 1:4



SECTION B-B



D3499-3 CABLE GUARD

NOTES:

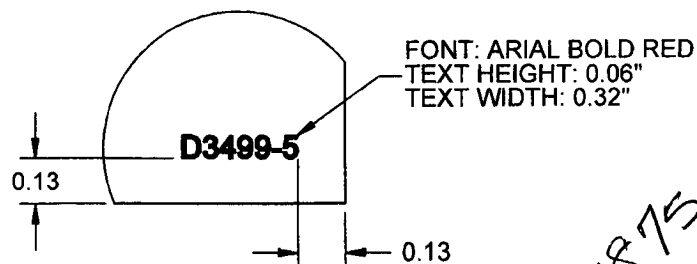
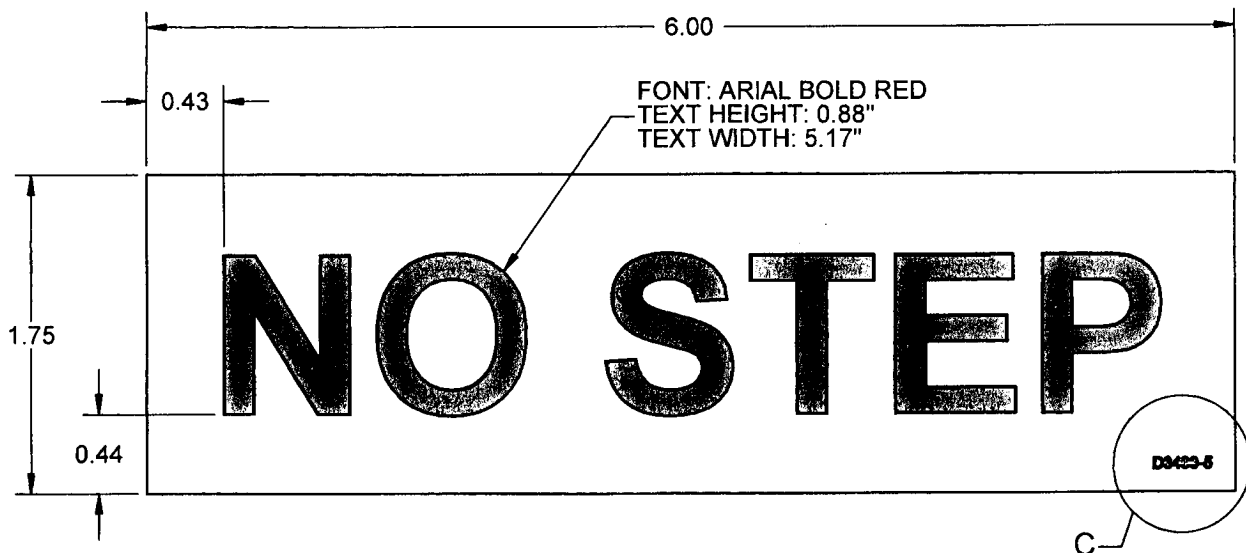
- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL (MUHMWB)
- 2) PART IS SYMMETRICAL AT CENTER LINE
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3499	REV. B SHEET 4 OF 4
DATE 06.08.15		TITLE CABLE GUARD	SCALE 1:1



DETAIL C
SCALE 1:2

Wb 41875

D3499-5 PLACARD

NOTES:

- 1) MATERIAL: RED LETTERS ON WHITE ADHESIVE BACK VINYL
MANUFACTURED FROM 3M 7 MIL MASKING FILM #8522CP OR
AVERY IPM #2031. SIZE IS 6.00" LONG" x 1.75" WIDE
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DART AÉROSPACE LTD		Work Order: 41875
Description: CABLE GUARD		Part Number: D3499-3
Inspection Dwg: D3499-3, Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article

☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .281	+ .005 - .001	.282	*			
Ø .500	+ .006 - .001	.500	*			
1.755	+/- .010	1.750	*			
2.605	+/- .010	2.600	*			
2.734	+/- .010	2.731	*			
3.255	+/- .010	3.260	*			
1.164	+/- .010	1.167	*			
.950	+/- .010	.950	*			
7.200	+/- .010	7.206	*			
12.450	+/- .010	12.450	*			
23.950	+/- .010	23.950	*			
35.450	+/- .010	35.450	*			
40.700	+/- .010	40.700	*			
46.736	+/- .010	46.736	*			
46.950	+/- .010	46.950	*			
47.900	+/- .010	47.900	*			
2.00	+0.000/- .030	1.985	✓			
0.25	+/- .030	0.249	✓			
0.63	+/- .030	.630				

Measured by: B / A	Audited by: [Signature]	Prototype Approval: [Signature]
Date: 8-9-18	Date: 08/10/03	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

51113

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